

Date: Thursday, 16/10/2008 10:07:09 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BO 105 SKID TUBE 'I' BEAM
Job Number	: 42623		
Estimate Number	: 11075		
P.O. Number	:	Part Number	: D2976
This Issue	: 16/10/2008 S.O. No. :	Drawing Number	: D2976 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SKIDTUBES	Drawing Revision	: A1
Previous Run	: 42269	Material	:
Written By	:	Due Date	: 31/10/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JW 08.10.16</u>		
Comment	: Est. C 02.10.30 Re-format KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963084	Extrusion
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Comment: Qty.: 2.1000 Each(s)/Unit Total : 4.2000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2963-084 Extrusion B14459Jb 8-10-16

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut D2963-084 extrusion to length: (82.00")

Use Jig DT8546 to drill pilot holes

Open holes to finish size per dwg D2976

Deburr

Jb 8-10-16

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Jb 8-10-16

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/10/21 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6Jb 8-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKID TUBE 'I' BEAM

Job Number: 42623

Part Number: D2976

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME 08-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

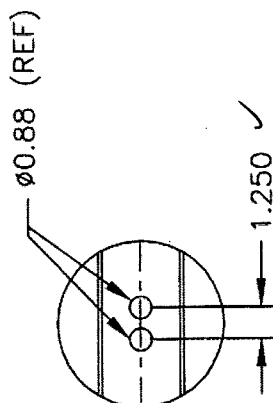
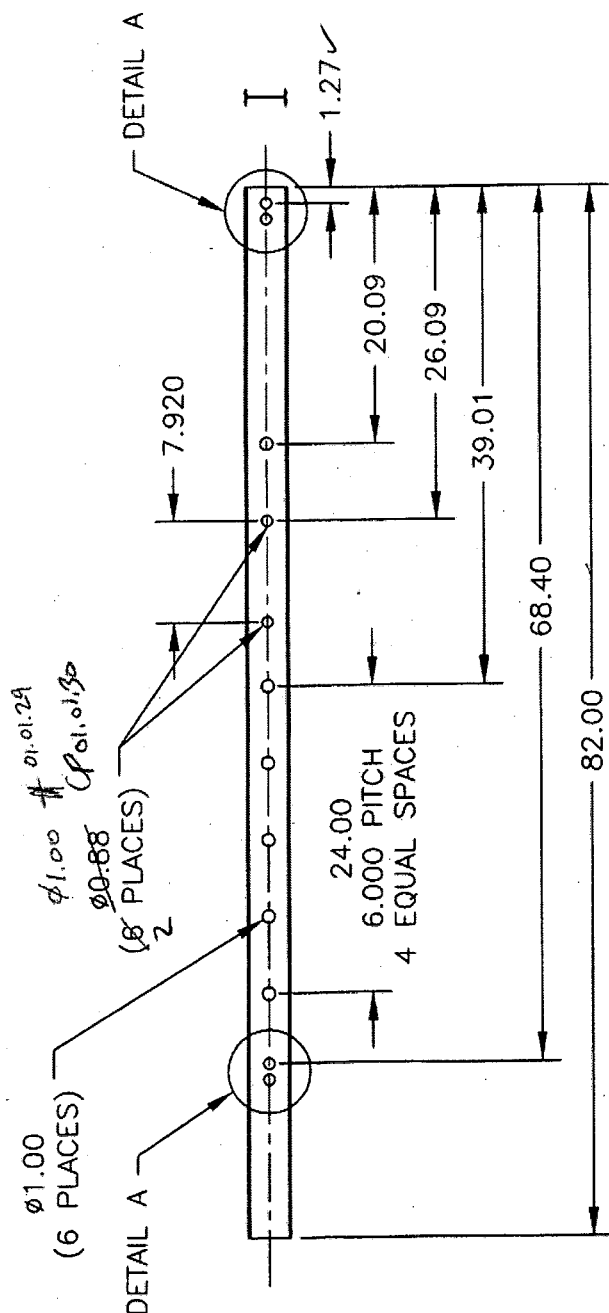
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF		DRAWN BY RF		DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]		APPROVED [Signature]		REV. A SHEET 1 OF 1	
DATE 00.03.14		TITLE WEB		SCALE 1:14	
A	00.03.14	NEW ISSUE			
AI	01.01.29	OPEN GROUND HANDLING HOLES TO $\phi 1.00$			

RELEASED
00.05.11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42623

MAKE FROM D2963-084 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries